

Work Order ID 68483

Thursday, April 14, 2011 10:02:28 AM



Page 1

Item ID: D3319-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate					
Start Date: 4/14/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 4/21/2011	Req'd Qty: 8.00		Customer:		

Reference:

Approvals:	Process Plan:	Date: 11-04-14	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
1010 .050	1-Cut as per Dwg D3319								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

121-4-18

8

121-4-18

28

5, 10/4/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68483

Thursday, April 14, 2011 10:02:28 AM



Page 2

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

Brake NC

NC BRAKE

Memo

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: B
2- Form flat on press using DT8776 block

SB 4/14/20



150



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8 4/14/21



160



Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch: _____

Large Fab

Memo

0.00

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: B
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod M 117139

B 11-5-26



W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 4/15/11

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 4/15/11

(X)

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320°F
2:10

0.00

M115128

8x 11/05/30

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 6 21 10:51 30

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: 407

11/5/31 822

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 822

MF 11-05-31

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:02:34 AM

Page 1

Work Order ID: 68483



Parent Item: D3319-1



Parent Item Name: Wearplate



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B05.10.14 Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased	No			100	sf	62.5000	0.628 	5.288421			

B11-4-18

Location

Loc Qty

Loc Code

MAT019

62.5

116268

62.5

116268

68

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	18483
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.980	✓		V RB02	
1.600	+/-0.010	1.600	✓		V	
2.660	+/-0.010	2.666	✓		V	
3.190	+/-0.010	3.192	✓		V	
3.563	+/-0.010	3.559	✓		V	
4.712	+/-0.010	4.709	✓		V	
0.60	+/-0.030	0.604	✓		V	
10.576	+/-0.010	10.576	✓		T RB02	
11.942	+/-0.010	11.942	✓		T	
18.09	+/-0.030	18.09	✓		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	3.17 x 5.57	✓		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	3.17 x 6.74	✓		V	
Ø0.190	+0.005/-0.001	0.194	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-18	Date: 11/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	JA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

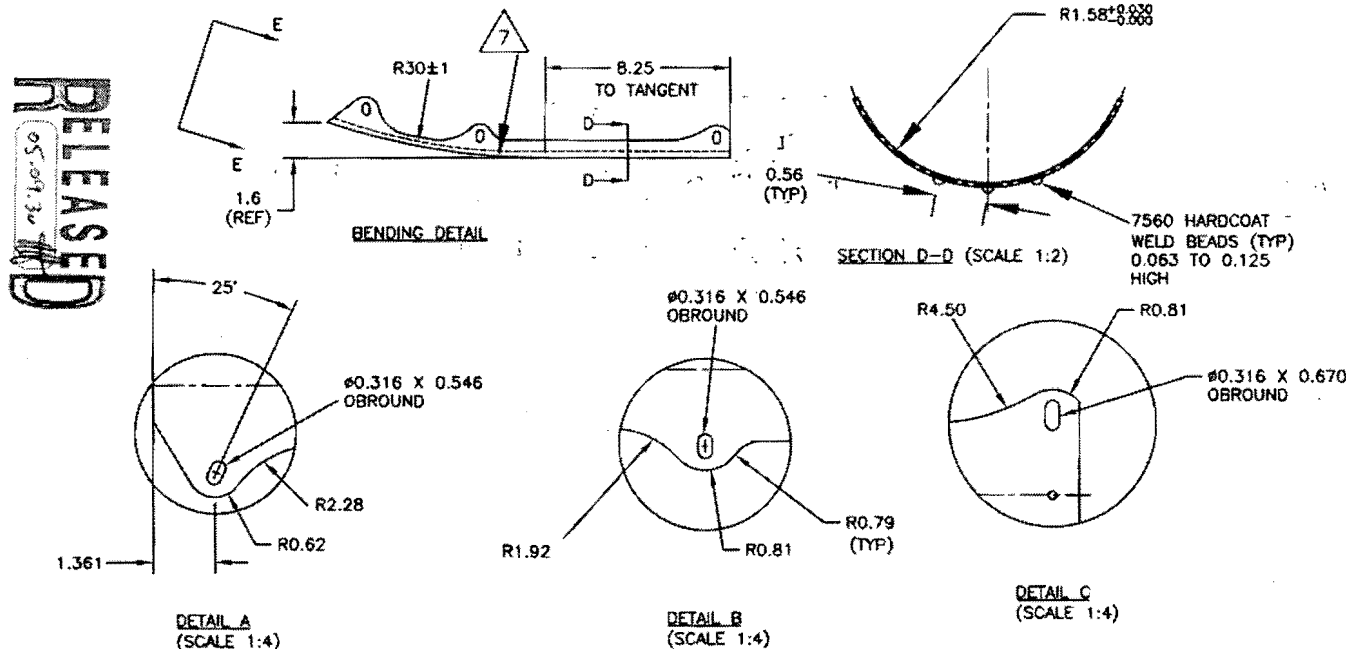
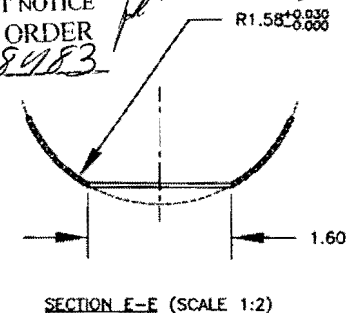
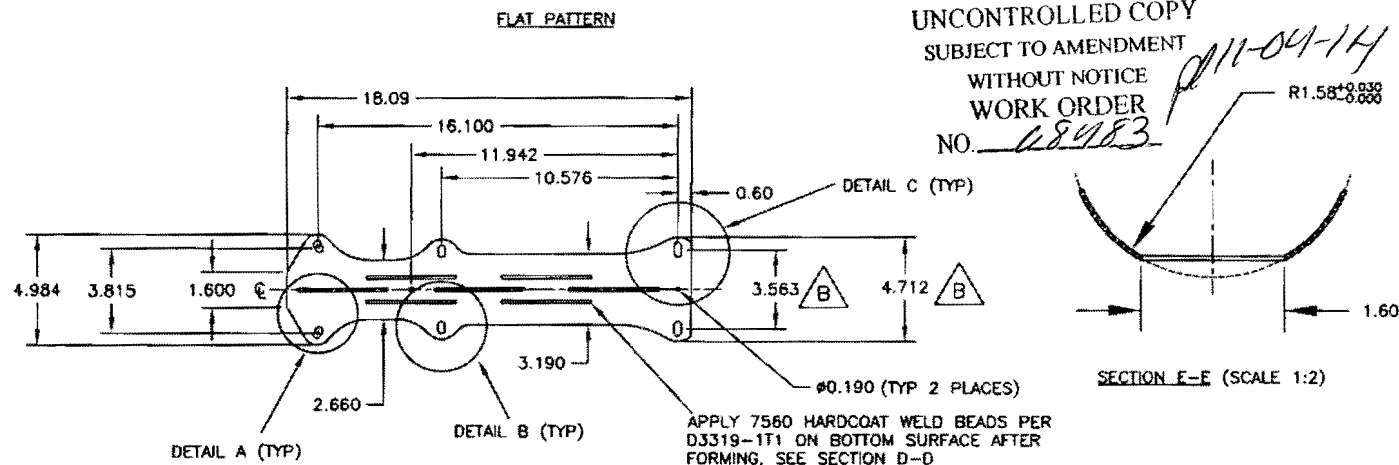
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 08983



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
	NEW ISSUE	
	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	

RELEASED
05.09.30

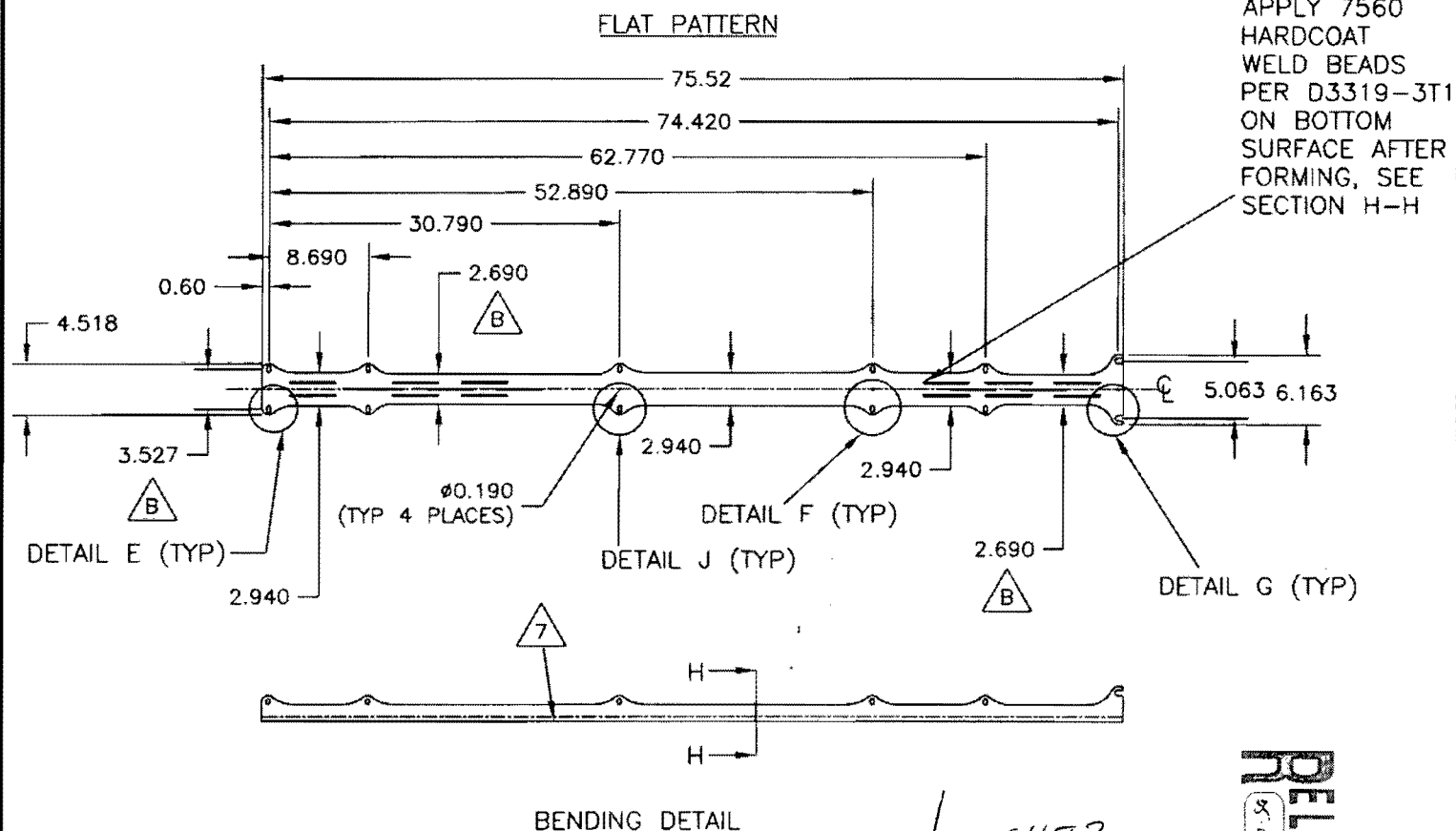
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	APPROVED	DRAWING NO.	REVISION
DATE	05.06.06	TITLE	WEARPLATE
DRAWN BY	APPROVED	DART AEROSPACE LTD	REV. B
		HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 5
			SCALE 1:15

RELEASED
55.07.30

21068483

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

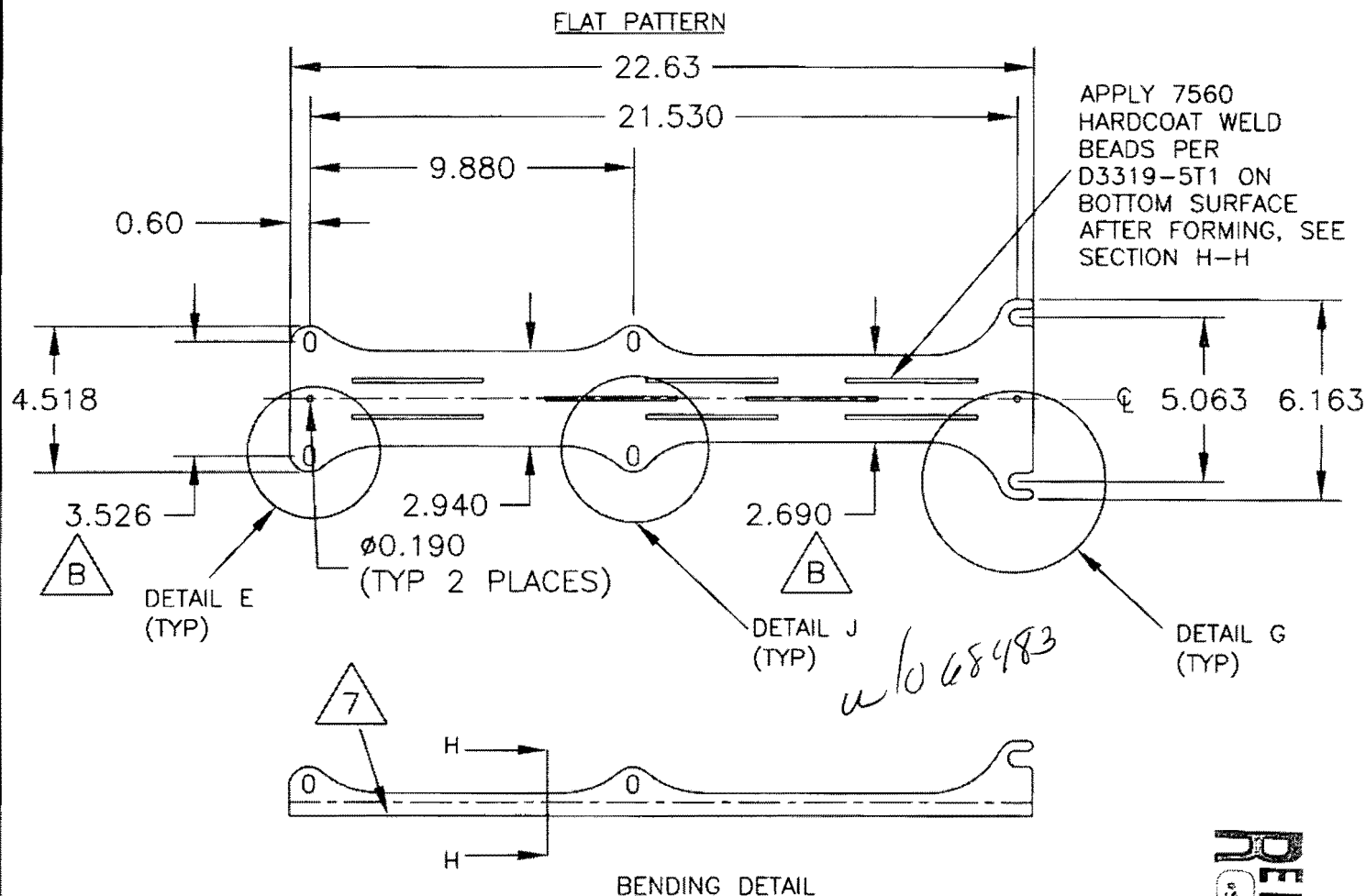
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	D31	DRAWN BY	D31	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	D3319	SHEET 3 OF 5
DATE	05.06.06			TITLE	WEARPLATE	SCALE 1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

05-09-30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

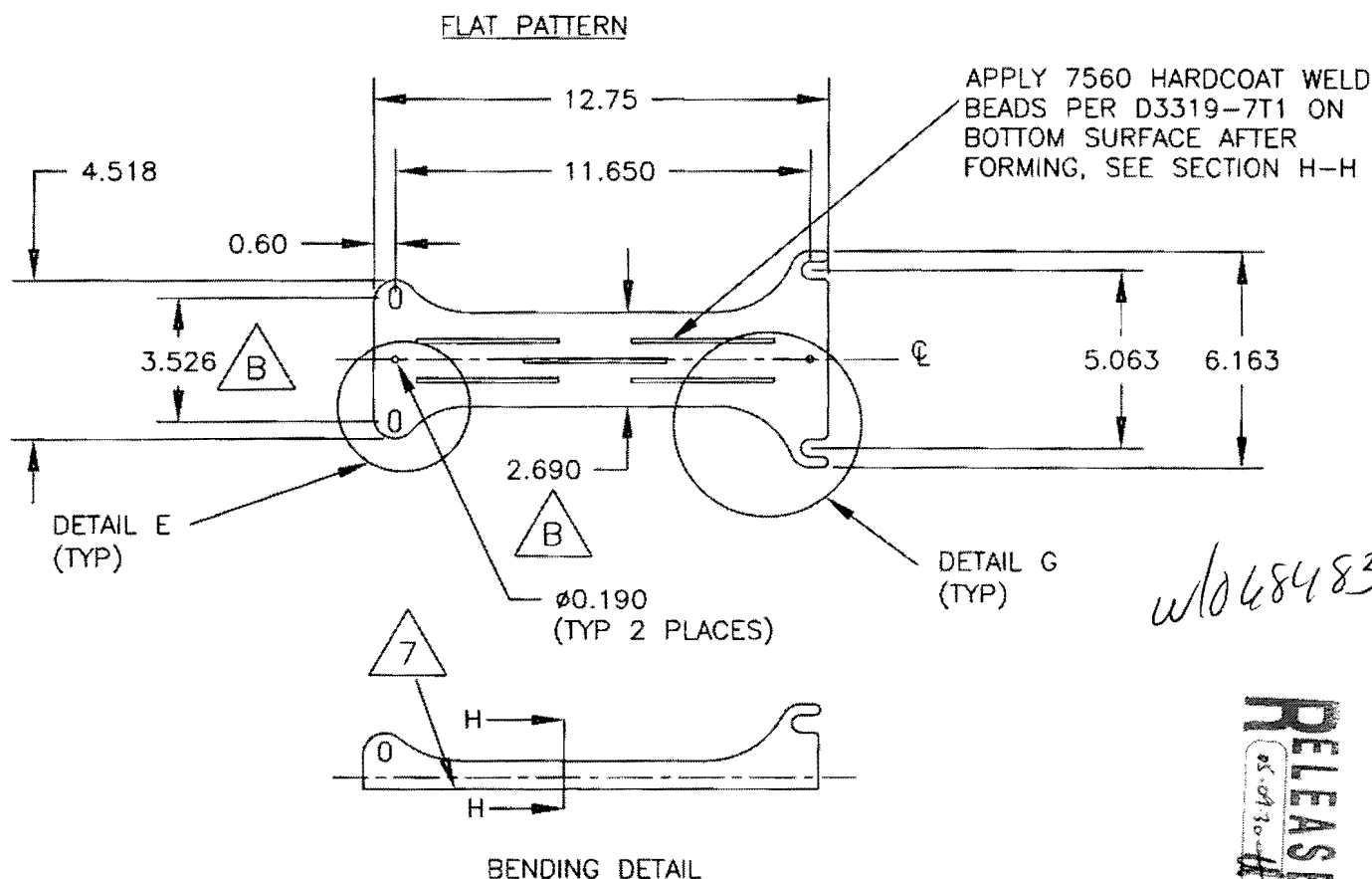
NOTE: Date & initial all entries



DESIGN	PH	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	GH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	

RELEASED
05-01-30-11

w/048483



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
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- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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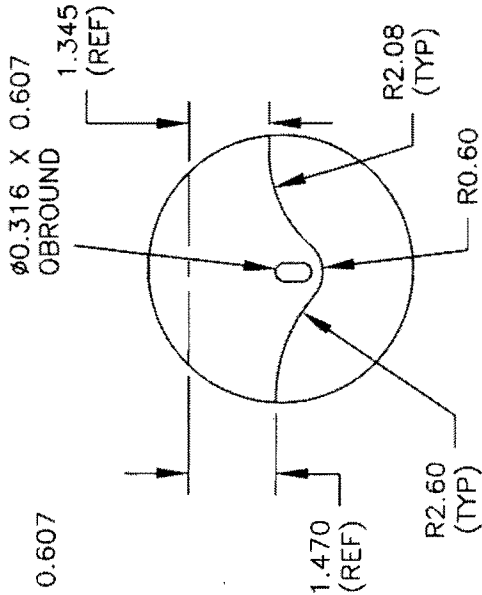
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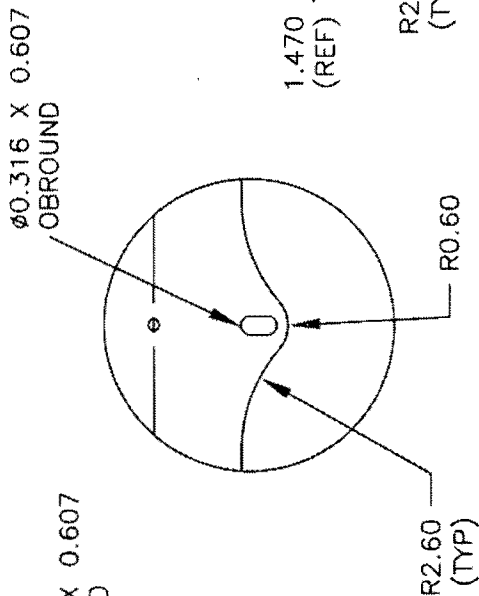
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

RELEASED
05.09.30

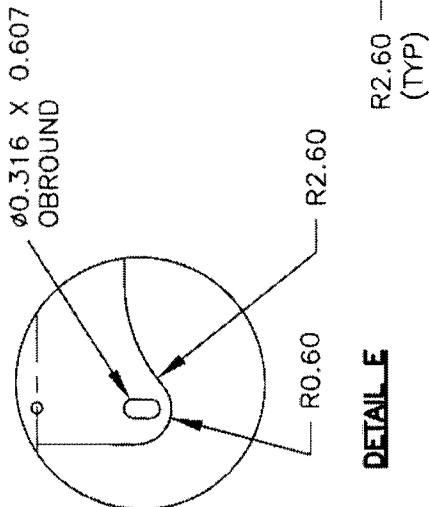
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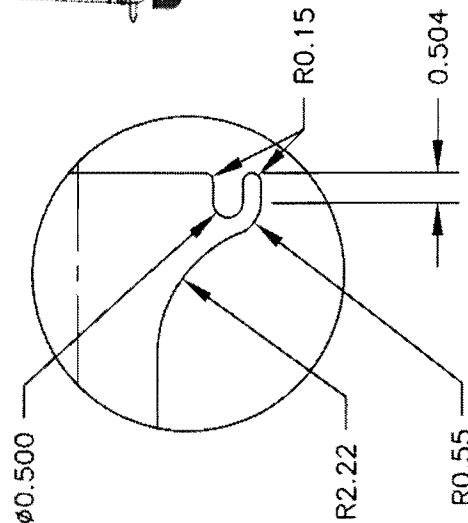
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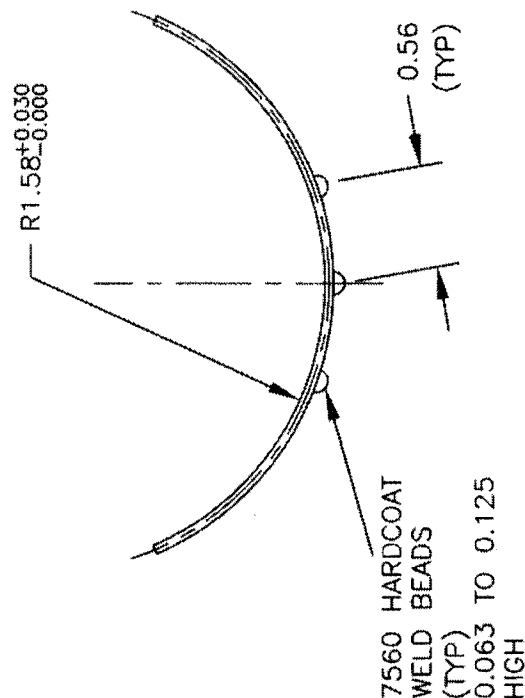
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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